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D3690-041
Job Sheet 183455



Part No: D3690-041

Job Qty: 2 ea

Part Name: Glareshield Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A 08-04-29 new issue DD verified by:ec IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec IPP Rev:C 08-09-08 added painting DD verified by:EC IPP Rev:D 08-10-07 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Stores/Pkg-2		Smb
100	Packaging	2 pcs	10/12/18	10/12/18	0.00	0.00	Packaging1-4		Smb
110	Small Fab	2 pcs	10/12/18	10/12/18	0.00	6.90	Small Fab-4		Smb
120	QC	2 pcs	10/12/18	10/12/18	0.00	0.00	QC5		38
130	SprayPaint	2 pcs	10/12/18	10/12/18	0.00	7.41	Spray Paint		AS OCT 30 2018
140	QC	2 pcs	10/12/18	10/12/18	0.00	0.00	QC14		OCT 31 2018 68
150	Packaging	2 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-1		OCT 3 - 2018 9-89
160	QC21-SA	2 Ea	10/12/18	10/12/18	0.00	0.00	QC21		OCT 31 2018

Adh pm 138835 Primer 138835 Paint 138835

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3213-4-03 ST 39	Rivet	70 Ea (35 ea)	90-Start up Operation	SO 27731 X30 SO 98033
D3690-1	Glareshield	2 Ea (1 ea)	90-Start up Operation	SO 68614
D3697-041	Tube Assembly	2 Ea (1 ea)	90-Start up Operation	5113138
D3698-1	Support Angle	2 Ea (1 ea)	90-Start up Operation	SO 56292
MS20426AD3-5 ST 31	Rivet	4 Ea (2 ea)	90-Start up Operation	F7533
NAS1149DN332J ST 26	Washer	4 Ea (2 ea)	90-Start up Operation	fml 27831

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CR3213-4-03	70	215	0
	D3690-1	2	2	0
	D3697-041	2	0	0
	D3698-1	2	6	0
	MS20426AD3-5	4	7,762	0
	NAS1149DN332J	4	468	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval																																																																													
Desc: _____ _____ _____		Part: D3690 - 041 Job No: 183455 Serial No/Batch: S120644 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/23/18				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																													
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No</td></tr> <tr><td>Design</td><td>☐</td><td>O</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>O</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Si</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td></tr> <tr><td>LOA</td><td>☒</td><td>Product Improvement</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td></tr> </table>		Environment	☐	No	Design	☐	O	Doc/Data	☐	O	Equip/Tooling	☐	Si	Handling/Pre	☐	Training	Material	☐	Use for Testing	Internal Transport	☐	Poor Information	Tribal Knowledge	☐	Rushing	LOA	☒	Product Improvement	Substation	☐	Process Improvement	Past Expiry Date	☐	Manufacturing Process	Misidentified	☐	Past Due	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Crimp/Kink/Ripple/wave</td> <td style="width:33%;">Inspection incomplete, _____</td> <td style="width:33%;">Material Loss/Surge</td> <td style="width:33%;">☐ Positioned Wrong</td> </tr> <tr> <td>Cuffs</td> <td>Contamination</td> <td>_____</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>Crushing</td> <td>Countersink</td> <td>_____</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>Heat Treat</td> <td>Cut Too Short</td> <td>_____</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>Wave/Twist in Tube</td> <td>Instructions Incomplete/Unclear</td> <td>_____</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>_____</td> <td>☐ Part Moved</td> </tr> <tr> <td colspan="3"></td> <td>☐ Drawing</td> </tr> <tr> <td colspan="3"></td> <td>☐ Finish</td> </tr> <tr> <td colspan="3"></td> <td>☐ Misread</td> </tr> <tr> <td colspan="3"></td> <td>☐ Turning Sequence</td> </tr> </table>						Crimp/Kink/Ripple/wave	Inspection incomplete, _____	Material Loss/Surge	☐ Positioned Wrong	Cuffs	Contamination	_____	☐ Outside Dimensions	Crushing	Countersink	_____	☐ Over/Under tolerance	Heat Treat	Cut Too Short	_____	☐ Part Incorrect	Wave/Twist in Tube	Instructions Incomplete/Unclear	_____	☐ Part Lost/Missing	Marks/Chatter	Drill Holes	_____	☐ Part Moved				☐ Drawing				☐ Finish				☐ Misread				☐ Turning Sequence
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